











# Work Order ID 59708

Wednesday, June 09, 2010 3:11:37 PM

Page 1

Item ID:	D3910-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Crosstube Lug				Stop	
Start Date:	6/10/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	6/11/2010	Req'd Qty: 6.00		Customer:		
Reference:	REWORK					

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-6-9</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3910	B								
190	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	Memo							
	Powder Coating	PULL FROM STK D3910-1 X 6 B 57194							
		TOUCH-UP OR REPOWDER COAT IF NECESSARY							
		M114841							
200	QC3- Inspect Part Finish	0.00							
	QC	Memo							
	Quality Control								
210	Identify as per dwg & Stock Location: <u>508</u>	0.00							
	Packaging	Memo							
	Packaging	ID AND STOCK UNDER NEW BATCH NUMBER							

10/06/15  
 START: 2:00pm  
 Temp: 320°  
 Fin: 2:30pm  
 10/06/15  
 X6 0  
 X6 0  
 E BR 10-6-15.  
 10-6-15 (66)

**Work Order ID 59708**

Wednesday, June 09, 2010 3:11:37 PM

Page 2

Item ID: D3910-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug

Start Date: 6/10/2010 Start Qty: 6.00

Required Date: 6/11/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

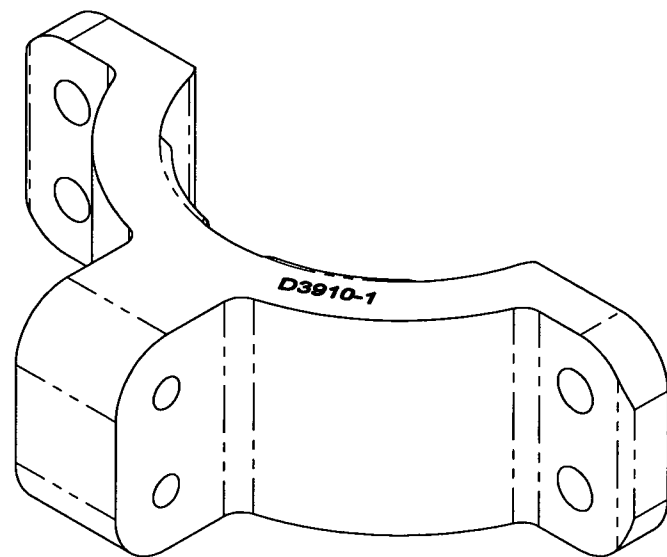
QC

Memo

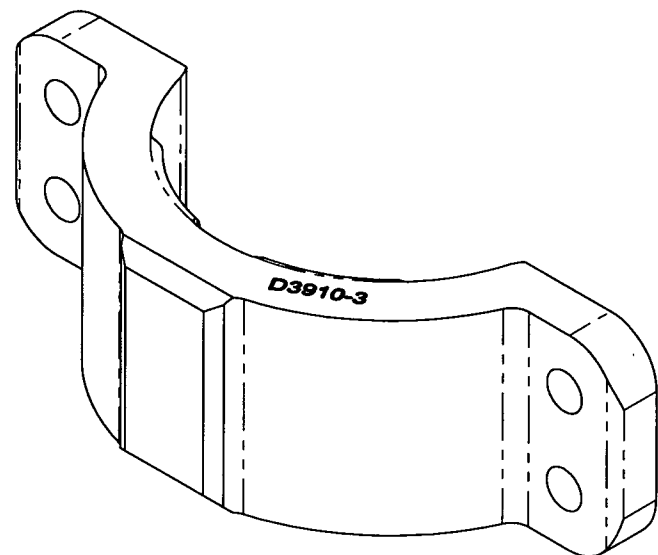
0.00

Quality Control

10/06/16 *[Signature]*  
MF 10-6-12



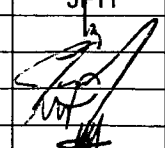
**D3910-1 X-TUBE LUG**

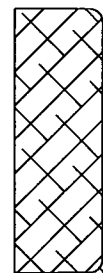


**D3910-3 X-TUBE LUG**

**RELEASED**  
2010-03-22  
*MP*

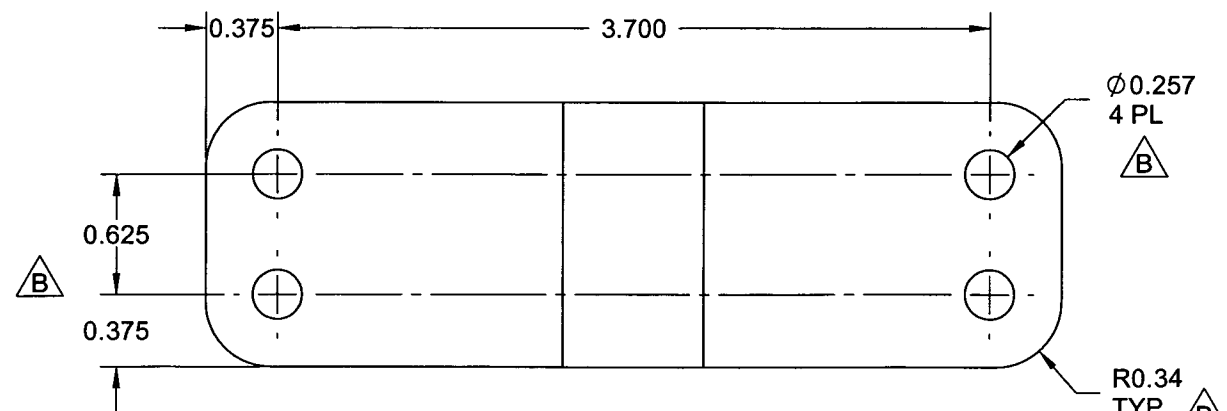
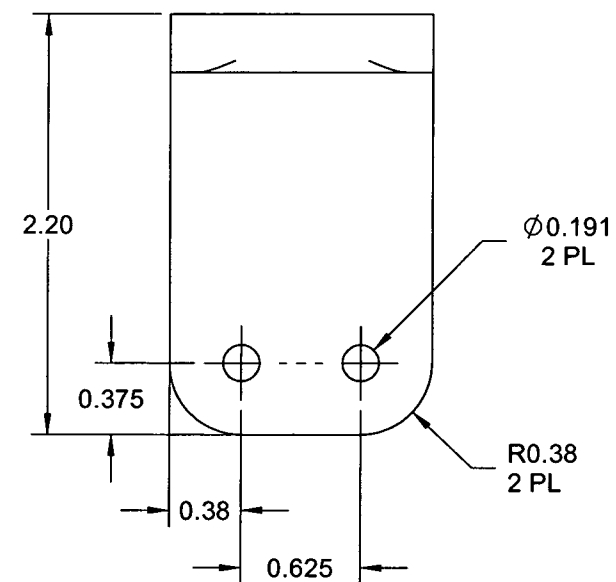
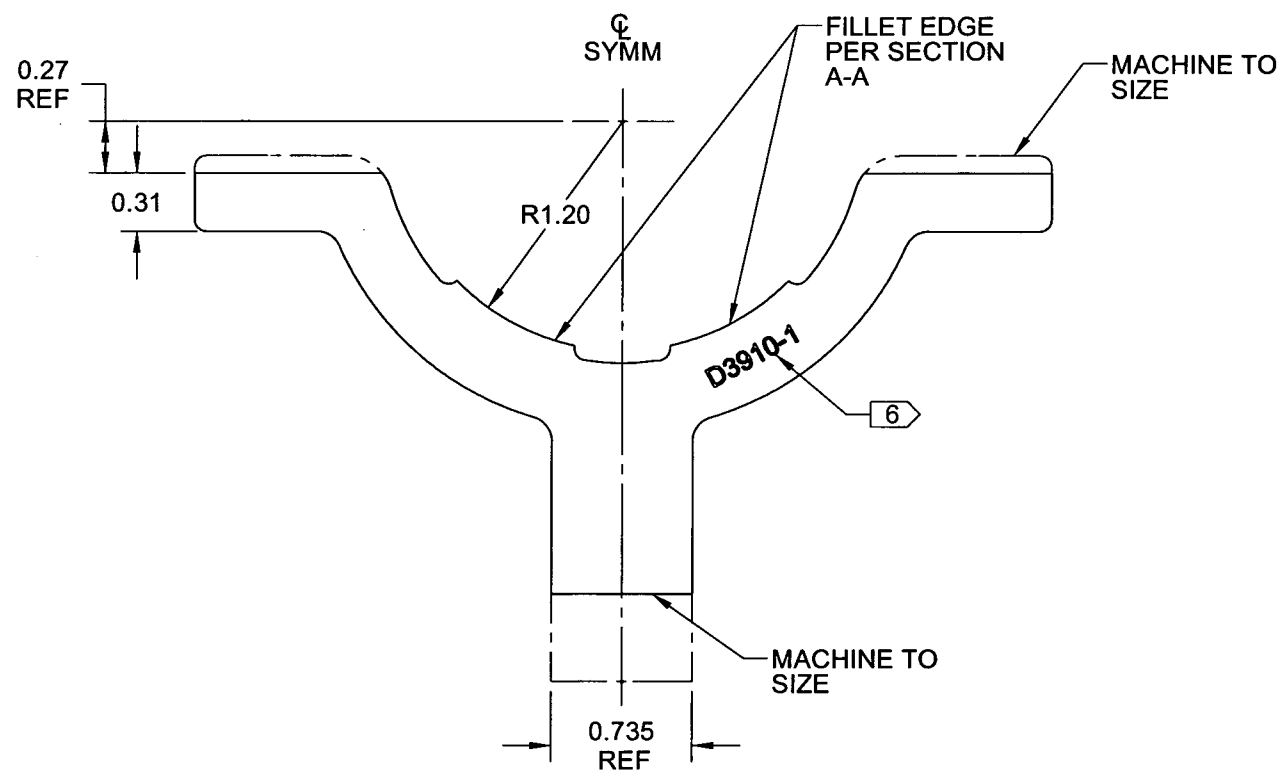
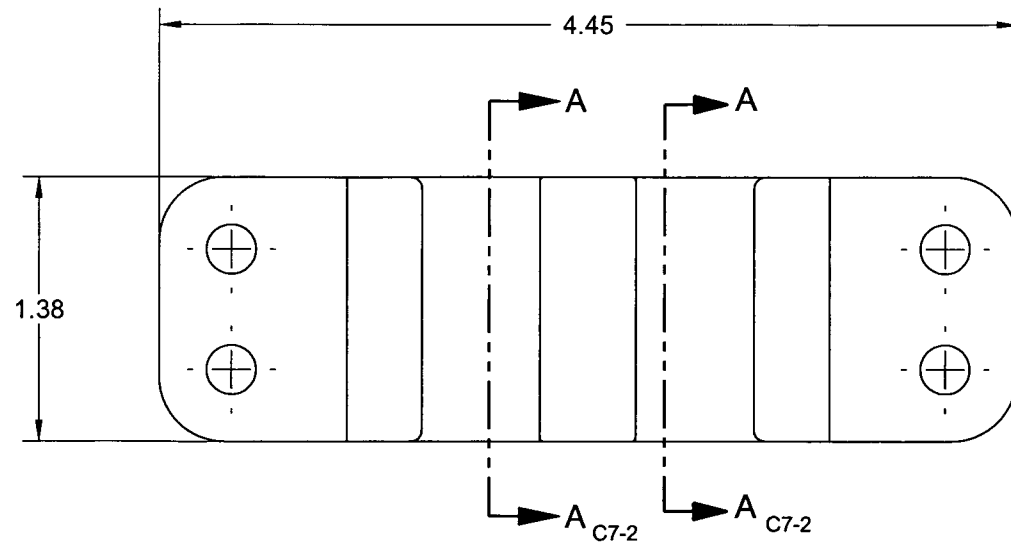
- NOTES:**
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
  - 7) WEIGHT -1: 0.32 lbs  
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.		REV. B
MFG. APPR.		D3910		SHEET 1 OF 3
APPROVED		TITLE		SCALE
DE APPR.		X-TUBE LUG (350)		NTS
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ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL

**SECTION A-A** C4-2  
C5-2



**D3910-1 X-TUBE LUG**

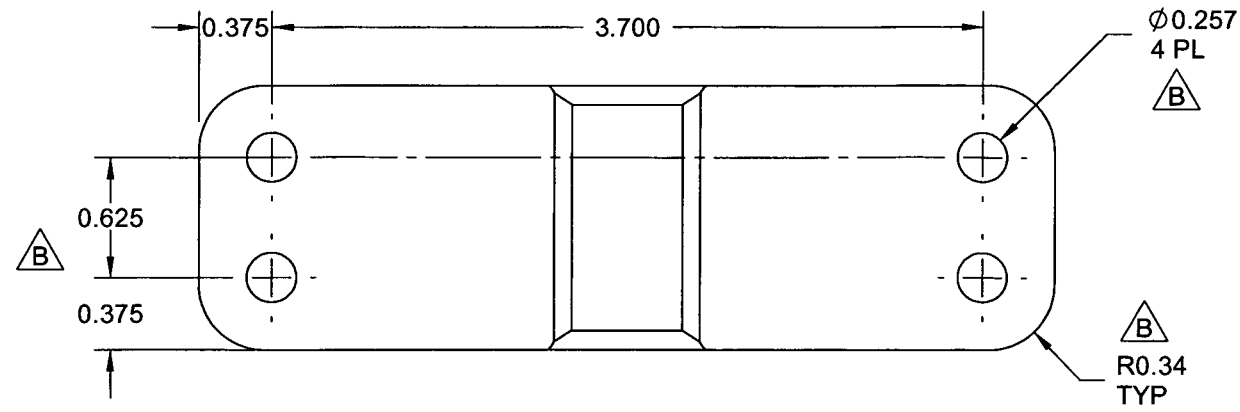
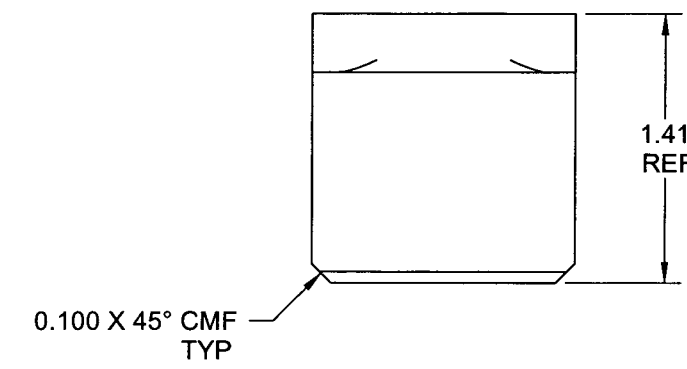
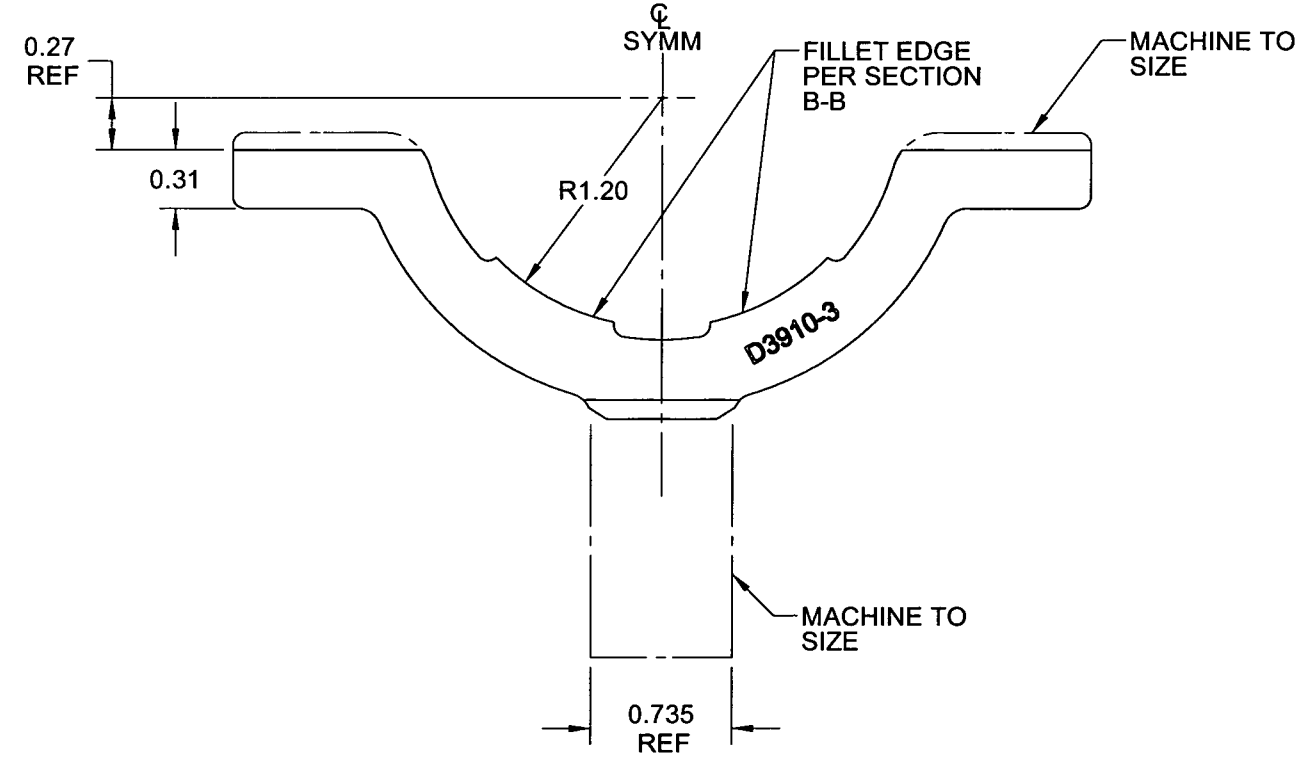
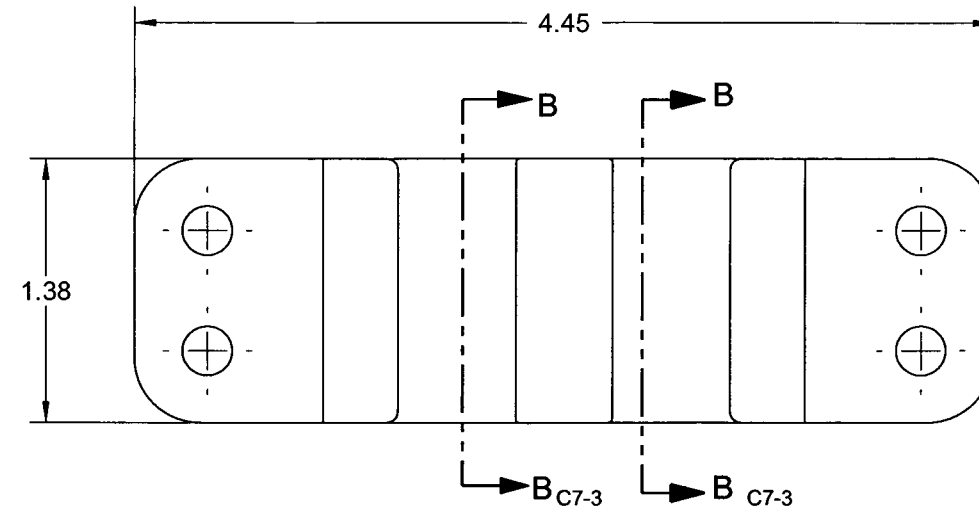
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2010-03-22  
*MP*

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**SECTION B-B**  
C4-3  
C5-3



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-3 X-TUBE LUG**

**RELEASED**  
2010-03-22

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MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>X-TUBE LUG (350)</b>	NTS
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